

# Work Order ID 71982

Thursday, July 14, 2011 3:30:22 PM



Page 1

Item ID: D205-564-011

Accept



Setup Start



Revision ID:

Item Name: Bearpaw

Stop



Start Date: 7/14/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan:

*[Signature]*

Date: 11-07-24

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2521	Rev J

100		0.00							
	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	Photocopy blue file and type labels per PPP D205-564-011 CHG008								

*hl 11 10 31 (8)*  
*for MLT 11-10-26 (8)*

151	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									

*sp 11-10-27*

160	QC4- 100% Inspect kits for completeness	0.00							
QC	Memo	0.00							
Quality Control									

*W 11 10 31 (8)*

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 71982**

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Page 2

Item ID: D205-564-011

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Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 7/14/2011 Start Qty: 8.00



Cust Item ID:

Required Date: 7/22/2011 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170  Packaging	Identify as per dwg & Stock Location: <u>24</u>  Memo <u>Reoc</u>	0.00  0.00						<u>11/10/31</u>	
180  QC	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00							<u>11/11/01</u>
Quality Control									<u>mf</u> <u>11-10-31</u>

**Dart Aerospace Ltd**

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**NOTE:** Date & initial all entries

# Picklist Print

Thursday, July 14, 2011 3:30:28 PM

Page 1

Work Order ID: 71982

Parent Item: D205-564-011

Parent Item Name: Bearpaw



Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP F00.01.20 Changed pick list, MPP 2019, CHG006 EC  
 IPP Rev:G 06-08-28 As per Rev E JLM  
 IPP Rev:H 08-01-11 Added Step #2 JLM Verified BY:EC  
 IPP Rev:I 08-10-01 New Manufacturing Method JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2521  Bearpaw 205		Manufactured	No			151	Each	1.0000	2	16			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST495		1							
					54892	1							
D2182B055  Clamp Cushion Black 5.5" Long		Manufactured	No			151	Each	7.0000	8	64			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST402A		7							
					68746	7							
D2274  Radius Block		Manufactured	No			151	Each	479.0000	20	160			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST010		479							
					68942	179							
					69736	200							
					69773	100							

73571  
16x.

BZ8746 SP  
B66063.

SP 11-00-27  
B72121 160x.

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

Page 2

Thursday, July 14, 2011 3:30:29 PM

Work Order ID: 71982

Parent Item: D205-564-011

Parent Item Name: Bearpaw

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 8.00

Required Qty: 8.00

D2529

Washer

Manufactured No

151

Each

565.0000

20

160

LocationLoc QtyLoc Code

ST016

565

66953

315

71161

250

SP.  
B73486 160x

D2947

Clamp

Manufactured No

151

Each

22.0000

8

64

LocationLoc QtyLoc Code

ST457

22

63320

22

SP.  
B72134 60x  
B73415 4x

D3544-041

Clamp

Manufactured No

151

Each

11.0000

4

32

LocationLoc QtyLoc Code

ST458

11

68994

11

SP.  
B72150 21x

AN4-13A

Bolt

Purchased No

151

Each

666.0000

8

64

LocationLoc QtyLoc Code

ST357

666

117962

72

118078

594

SP 11-10-27.  
m118706 8x  
5ex

Thursday, July 14, 2011 3:30:29 PM

Shop Packet Print

Page 2

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

**Part No:** \_\_\_\_\_ **PAR #:** \_\_\_\_\_ **Fault Category:** \_\_\_\_\_ **NCR:** Yes No **DQA:** \_\_\_\_\_ **Date:** \_\_\_\_\_  
**Resolution:** \_\_\_\_\_ **Disposition:** \_\_\_\_\_ **QA: N/C Closed:** \_\_\_\_\_ **Date:** \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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# Picklist Print

Thursday, July 14, 2011 3:30:29 PM

Work Order ID: 71982

Parent Item: D205-564-011

Parent Item Name: Bearpaw

Start Date: 7/14/2011

Required Date: 7/22/2011

Start Qty: 8.00

Required Qty: 8.00

AN4-15A  
Bolt

Purchased No

151 Each

343.0000

20 160



m 118648 Sp.

Location

Loc Qty

Loc Code

ST357

200

117423

200

ST358

143

117872

43

118112

100

AN960JD416 NAS1149D0463J

Purchased No

151 Each

0.0000

20 160



Washer



m 119042 Sp.

MS21042L4

Purchased No

151 Each

4,043.000

20 160



Nut



Sp 11-10-27  
m 118451

Location

Loc Qty

Loc Code

ST300

4043

117441

1796

117601

747

117885

1500

**Dart Aerospace Ltd**

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DESIGN	<i>CB</i>	DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>CP</i>	APPROVED		DRAWING NO.	REV. J
				D2521	SHEET 1 OF 3
DATE	06.07.28			TITLE	SCALE
				205 BEARPAW	NTS
A	95.11.28	NEW ISSUE			
B	96.01.11	SHOW BENDING MOVE HOLES			
C	96.01.29	ADJUST HOLE LOCATION FOR TOOLING			
D	96.05.14	ADJUSTED BEAR PAW THICKNESS			
E	96.12.18	43.500 WAS 46.750			
F	97.05.07	ADDED REAR POCKET, MOVED HOLES			
G	98.08.06	ADD C'BORE AND CHAMFER EDGES			
H	03.01.30	CHANGE GEOMETRY FOR RUN-ON LDG.			
I	05.05.20	REMOVE BEND; CHANGE TOLERANCES			
J	06.07.28	CHANGE FOR FLOAT SKIDTUBE			

SHOP COPY  
RETURN TO:  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *71982*  
*R/11-07-14*

RELEASED  
*06 08.23*

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**Dart Aerospace Ltd**

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**DART**

DESIGN

DRAWN BY

**DART AEROSPACE LTD**

HAWKESBURY, ONTARIO, CANADA

CHECKED

APPROVED

DRAWING NO.

REV. J

**D2521**

SHEET 2 OF 3

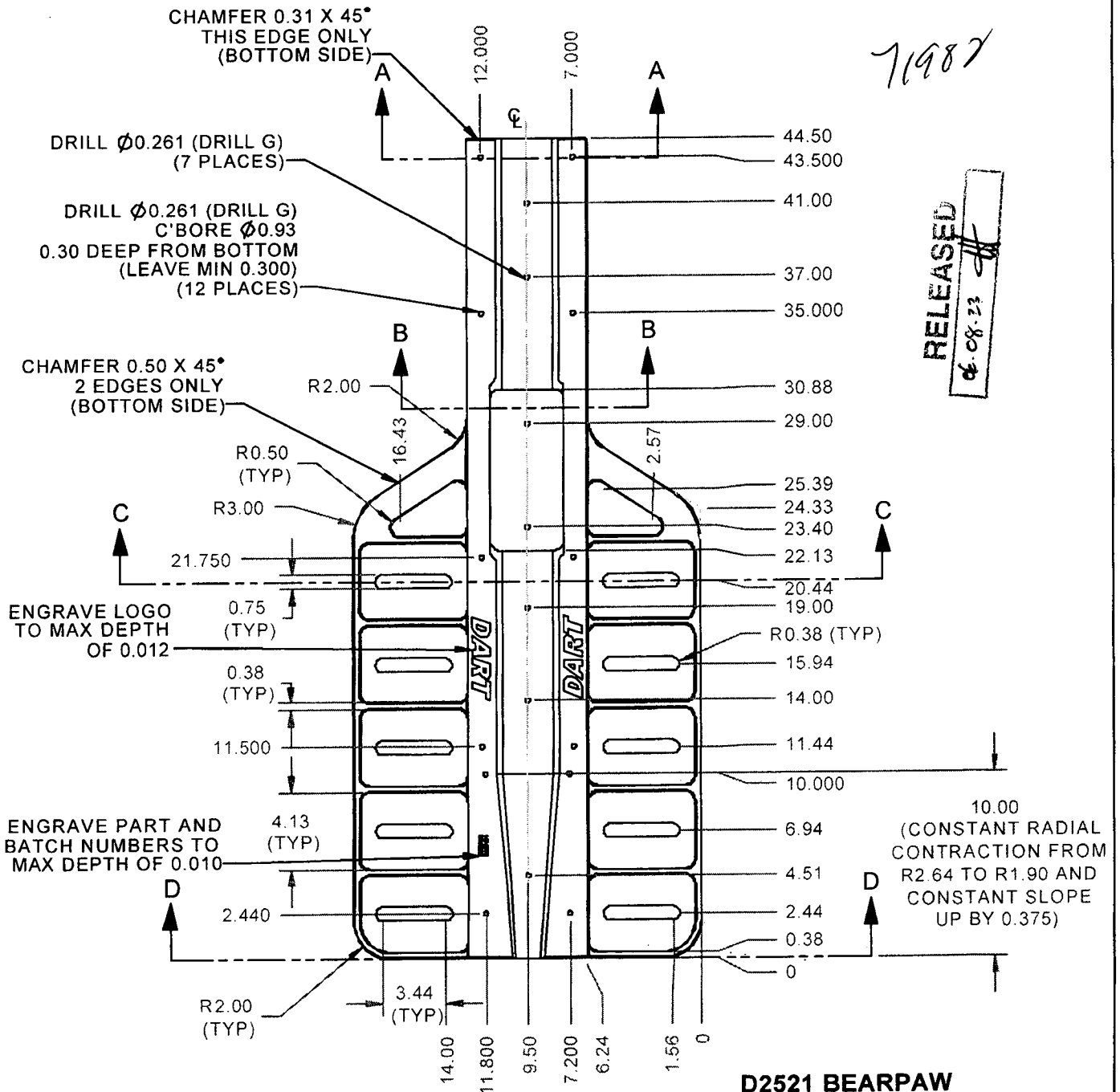
DATE

TITLE

SCALE

**06.07.28****205 BEARPAW**

1:8

**NOTES:**

- 1) MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689, 1.000 THICK (MACHINE TO 0.950)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.030
- 6) PART IS SYMMETRIC ABOUT C

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**Dart Aerospace Ltd**

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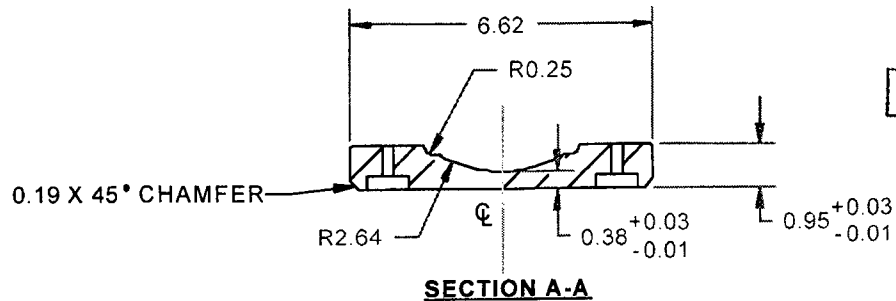
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**DART**

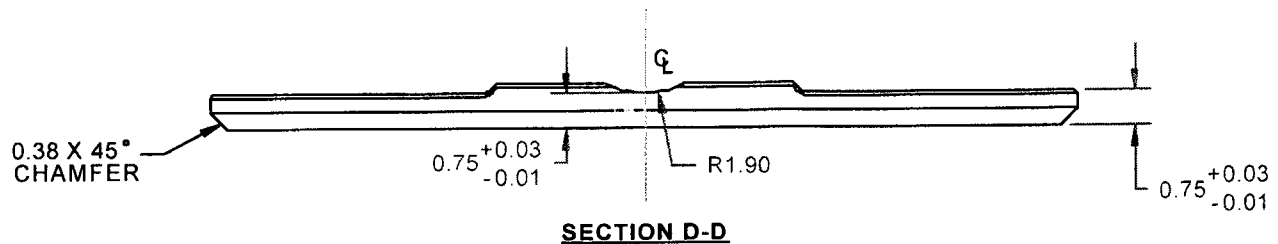
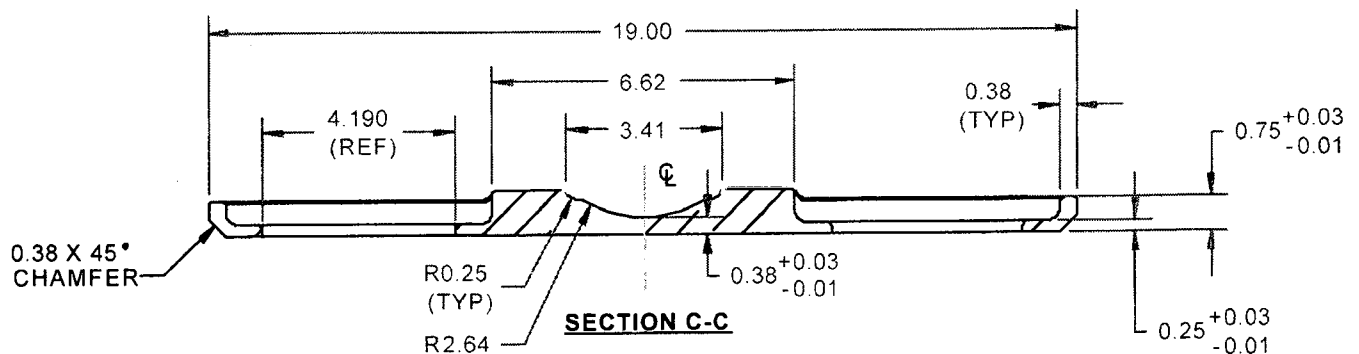
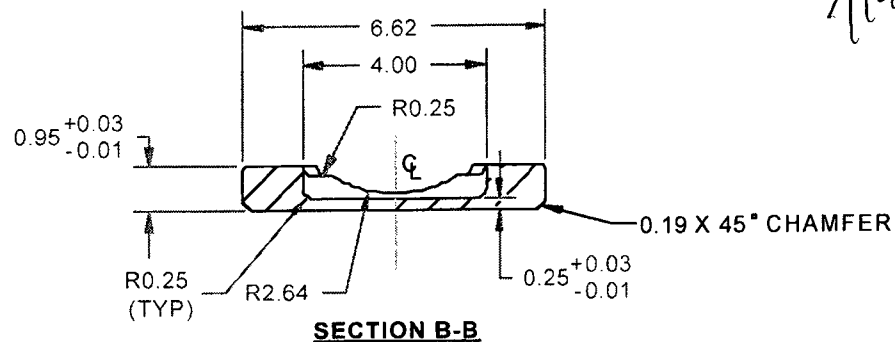
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CP	APPROVED #	DRAWING NO. D2521	REV. J SHEET 3 OF 3
DATE 06.07.28	TITLE 205 BEARPAW		SCALE 1:4



RELEASED

06.08.23 #

11982



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**NOTE:** Date & initial all entries



5.0 PARTS LIST

Qty	Part Number	Description
X	D205-564-011	BEARPAW INSTALLATION
8	D2182B055	RUBBER CUSHION
20	D2274	RADIUS BLOCK
2	D2521	BEARPAW
20	D2529	WASHER
8	D2947	CLAMP
4	D3544-041	CLAMP
8	AN4-13A	BOLT
20	AN4-15A	BOLT
20	AN960JD416	WASHERS
20	MS21042L4	NUT (OR MS21042-4)

Qty	Part Number	Description
X	DSI-9328-011	RUN-ON LANDING WEARPLATE KIT
2	D3511-041	WEARPLATE
16	AN4-17A	BOLT
4	AN4-11A	BOLT
4	AN970-4	WASHER
16	MS21042L4	NUT (OR MS21042-4)